

Work Order ID 79070

39.
79070

Page 1

January-19-12 10:03:27 AM

Item ID: D2916-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cable Guard, 212 Skidtube
 Start Date: 19/01/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 26/01/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/19 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2916	Rev D

100 0.00
 100 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2916 Dwg Rev: D Prog Rev: D 2-
 Deburr if necessary

B12-1-19
 (S) (4)

110 0.00
 110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

B12-1-19

120 0.00
 120 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 BATCH: 79070 1-Mill as per Folio FB077 Rev: AA
 & Dwg D2916 Rev: D 2-Deburr per dwg D2916 *

B12-1-19
 releases 4 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Stop *NR2*

[illegible]

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Work Order ID 79070***79070***

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January-19-12 10:03:27 AM

Item ID: D2916-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cable Guard, 212 Skidtube

Start Date: 19/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/1/31 98

P1201-30
(12)

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Picklist Print

January-19-12 10:03:31 AM

Page 1

Work Order ID: 79070

79070

Parent Item: D2916-1

D2916-1

Parent Item Name: Cable Guard, 212 Skidtube

Start Date: 19/01/2012

Required Date: 26/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-06-19 JLM
IPP Rev:B Now water jet 06-07-14 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			100	sf	377.8243	0.475	2			

MUHMWB10

UHMW 1" Black

**

1812-1-19

Location

Loc Qty

Loc Code

MAT018

118.18

120035

118.18

MAT019

259.6443158

117321

74.6

117738

95.8

117819

83.3

118814

1.5

119145

4.44431579

126035

(5) (4)

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DART AEROSPACE LTD		Work Order: 79070
Description: Cable Guard		Part Number: D2916-1
Inspection Dwg: D2916	Rev: B D 12-01-19	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	1.75	+/-0.030	1.755				
	38.94	+/-0.030	38.95	✓			
	35.94	+/-0.030	35.95	✓			
	32.25	+/-0.030	32.26	✓			
	29.00	+/-0.030	29.01	✓			
	15.00	+/-0.030	15.00	✓			
	11.31	+/-0.030	11.32	✓			
	3.19	+/-0.030	3.200				
	2.000	+/-0.010	2.009	✓			
	21.125	+/-0.010	21.134	✓			
	37.938	+/-0.010	37.947	✓			
	Ø0.438	+0.005/-0.000	.438	✓			
	25.00	+/-0.030	25.01	✓			
	24.00	+/-0.030	24.01	✓			
	16.50	+/-0.030	16.51	✓			
	15.01	+/-0.030	15.02	✓			
	3.25	+/-0.030	3.26	✓			
	2.33	+/-0.030	2.34	✓			
A-A	0.78	+/-0.030	.786	✓			
	0.70	+/-0.030	.704	✓			
B-B	0.140	+/-0.010	.149	✓			
	0.360	+/-0.010	.369	✓			
	0.88	+/-0.030	.860	✓			
	1.31	+/-0.030	1.305	✓			
C-C	0.78	+/-0.030	.755	✓			
	0.33	+/-0.030	.340	✓			
	0.37	+/-0.030	.370	✓			
D-D	Ø0.438	+0.005/-0.000	.438	✓			
	Ø0.875	+/-0.010	.876	✓			
	Ø0.260	+0.005/-0.000	.260	✓			
E-E	0.37	+/-0.030	.370	✓			
	Ø0.875	+/-0.010	.876	✓			
J-J	1.44	+/-0.030	1.44	✓			
	0.063	+/-0.010	.055	✓			

Measured by: <i>RF</i>	Audited by: <i>[Signature]</i>	Prototype Approval: N/A
Date: 12/1/12	Date: 12/1/12	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue	P/O D205-665-015	KJ/RF <i>[Signature]</i>

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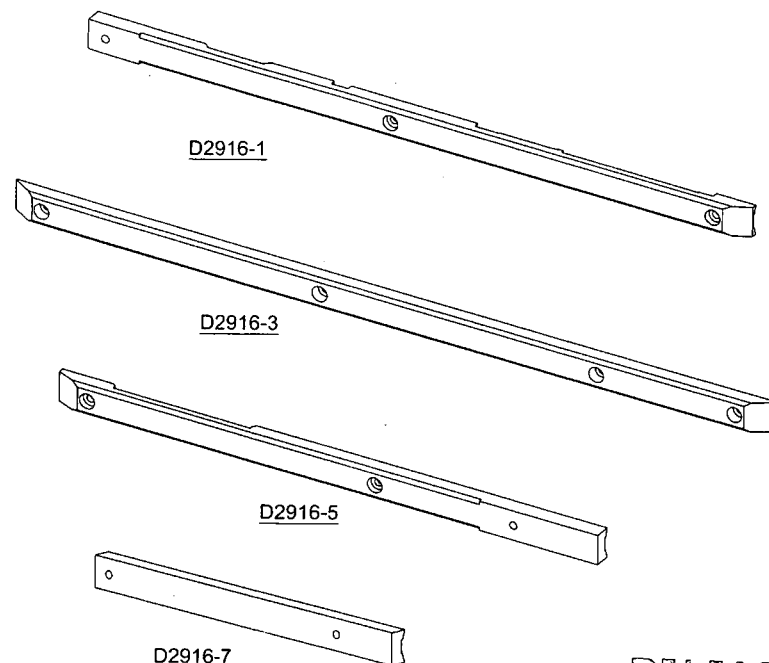
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NO 79070 M.L.J
12/01/19



NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF DART SPEC MUHMB10
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED RADII 0.020 TO 0.040
- 6) IDENTIFICATION: ENGRAVE P/N ON LOWER SIDE TO MAX DEPTH OF 0.010 AND MIN RADIUS OF 0.010
- 7) WEIGHT:

D2916-1 = 1.37 lbs
D2916-3 = 2.33 lbs
D2916-5 = 1.19 lbs
D2916-7 = 0.96 lbs

- 8) ENGRAVE TWO DART LOGOS (OPPOSITE AS SHOWN) ON UPPER SIDE TO MAX DEPTH OF 0.015 AND MIN RADIUS OF 0.250
- 9) MACHINE CONSTANT SECTION A-A
- 10) MACHINE CONSTANT SECTION B-B
- 11) MACHINE CONSTANT SECTION C-C
- 12) MACHINE CONSTANT SECTION F-F
- 13) MACHINE CONSTANT SECTION G-G
- 14) 25° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 15) 50° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 16) MACHINE SLOT WITH 0.063 RADIUS OF TRANSITION BETWEEN SECTIONS
- 17) ALL HOLES DRILLED ON CENTERLINES

RELEASED
2011-11-02

D	REVISE MACHINE SLOT. (ZN C5-2, C4-4, C4-5, C6-5) REVISE SECTIONS D-D, L-L, N-N	RF	11.10.07
C	REVISE D-D; ADD L-L, M-M & N-N; FOR D4406-041/-043 COMPATIBILITY	RF	11.08.17
B	ADD K-K FOR D2521 COMPATIBILITY	CP	00.02.24
A	NEW ISSUE	CP	99.09.29
REV.	DESCRIPTION	BY	DATE
DESIGN	#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	#	DRAWING NO.	REV. D
MFG. APPR.	#	D2916	SHEET 1 OF 6
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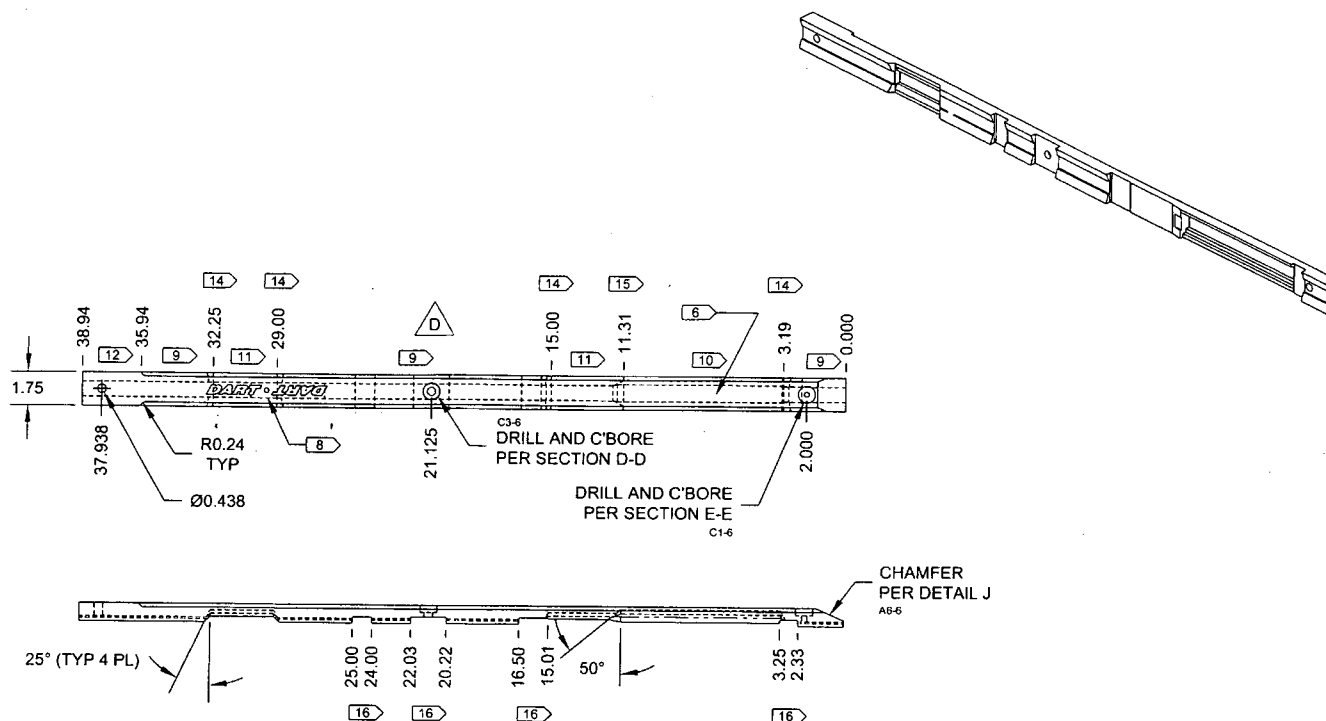
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D2916-1

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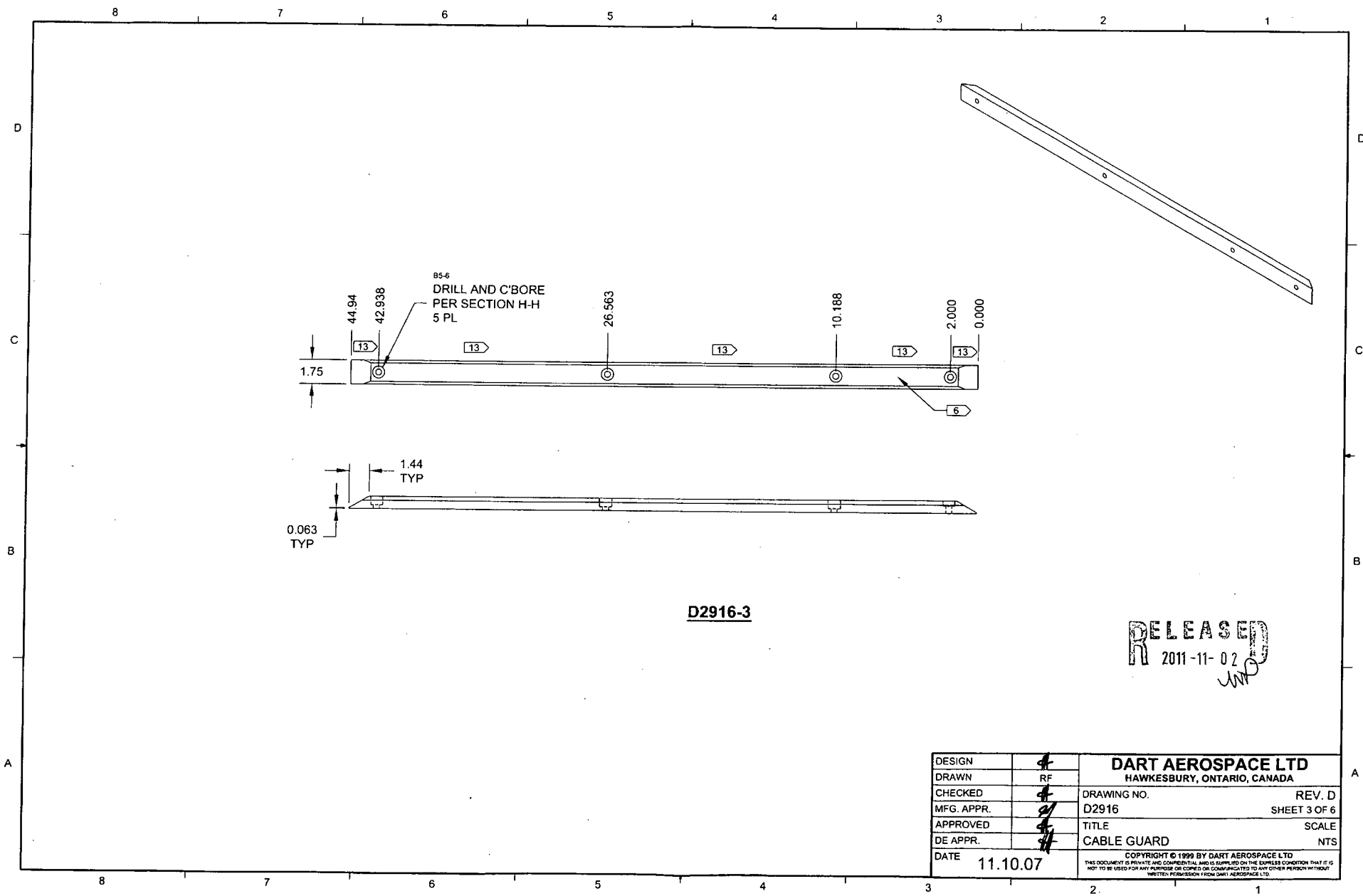
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D2916-3

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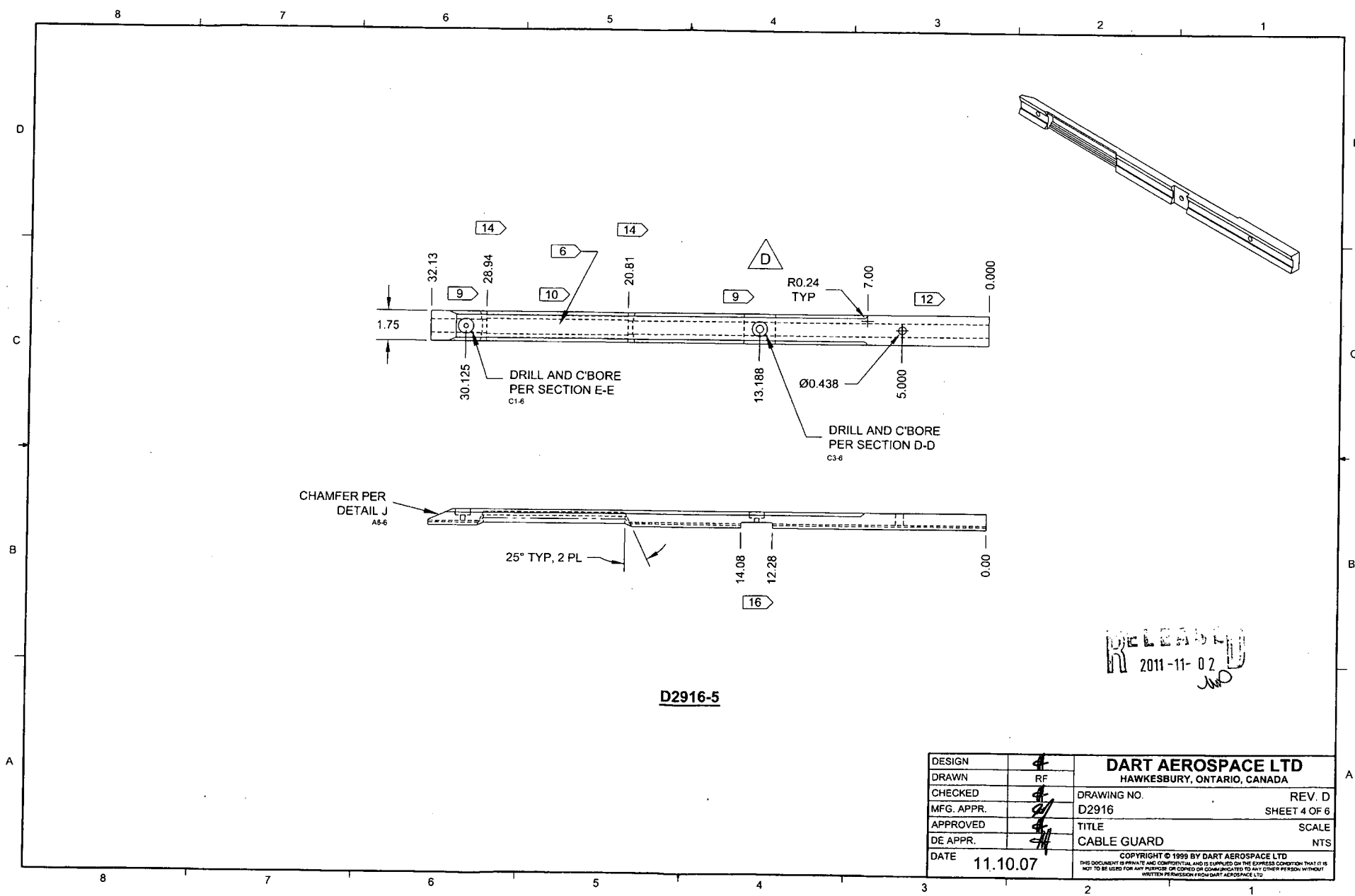
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D2916-5

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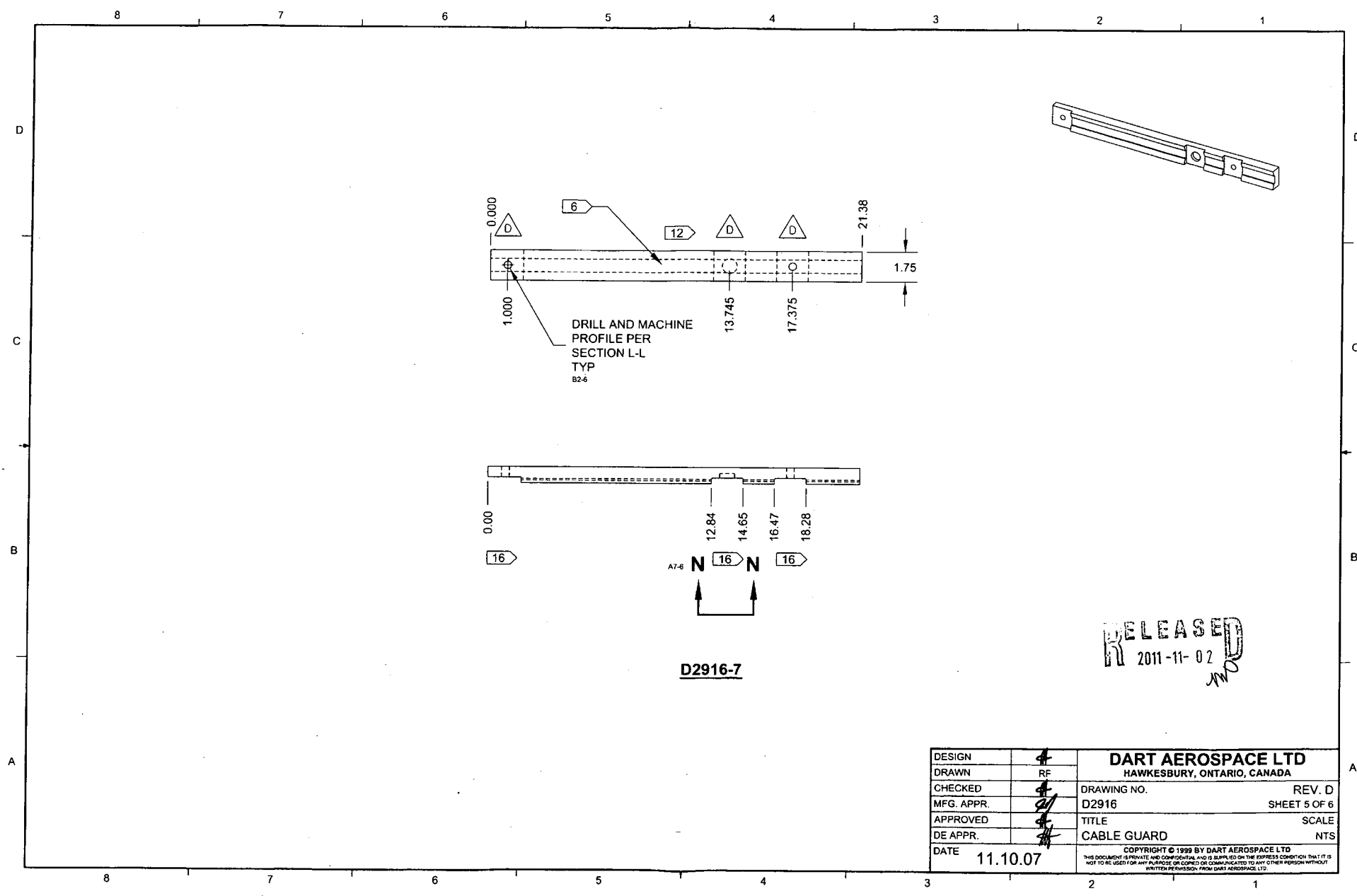
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D2916-7

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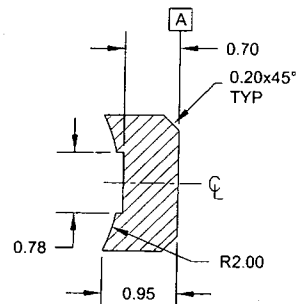
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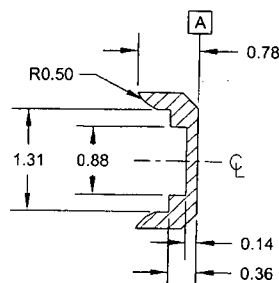
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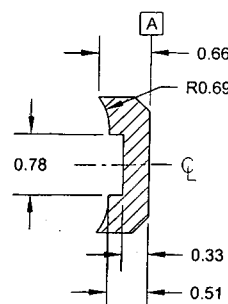
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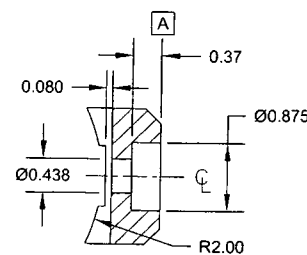
SECTION A-A
SCALE 4X
C3-2
C6-2
C4-4
C5-4



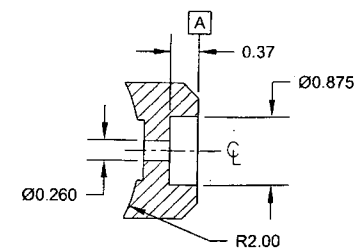
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C3-2
C5-4



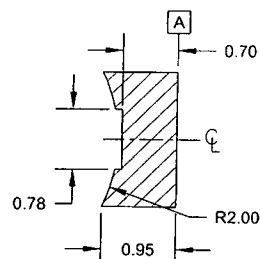
SECTION C-C
SCALE 4X
C5-2
C4-2



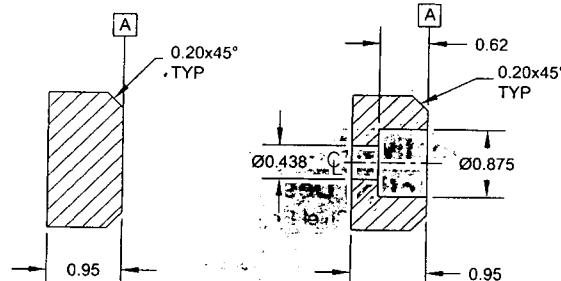
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C4-2
C3-4



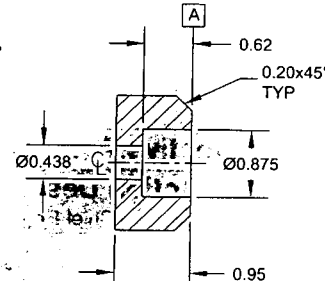
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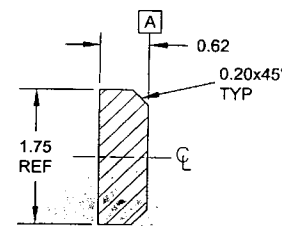
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C3-4
C5-5



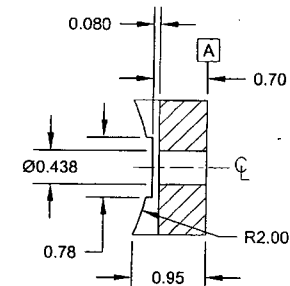
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C3-3
C4-3
C5-3
C6-3
C7-3



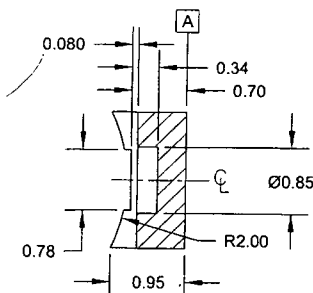
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C6-3



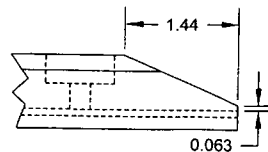
SECTION K-K
SCALE 4X
B3-2
B4-2
B5-2



SECTION L-L
SCALE 4X
C5-5



SECTION N-N
SCALE 4X
B6-5



DETAIL J
SCALE 4X
B3-2
B7-4

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2011-11-02

DESIGN	4	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4	DRAWING NO.	REV. D
MFG. APPR.	4	D2916	SHEET 6 OF 6
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